

Date: Wednesday, 10/11/2006 12:50:19 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP SPACER
Job Number	28939D	Part Number	D30657
Estimate Number	10380	Drawing Number	D3065 REV. B
P.O. Number	N/A	Project Number	N/A
This Issue	10/11/2006	Drawing Revision	B
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	11/15/2006
Previous Run	28738D	Qty:	60
Written By		Um:	Each
Checked & Approved By	<i>dk</i> 06-10-11		
Comment	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M102448</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>	
			<i>SAP 06-10-28 60</i>
		2-Deburr if necessary	<i>SAD 06-10-28 60</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAD 06-10-28 60</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>10/06/10/30 (58)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Deburr if necessary.	<i>SAD 06-11-06 60</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-7 PAR #: N/A Fault Category: Prod / FOB. ASS'N ^{met & spec} NCR: Yes No DQA: NP Date: 07/01/17
 QA: N/C Closed: ✓ Date: 07.01.17

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/10/17</u>	<u>4</u>	<u>2 scraps holes damage from water jet</u>	<u>QS1042</u>	<u>destroy</u>	<u>SAN 02/01/17</u>	<u>06/10/17</u>	<u>QS1042</u>	<u>06/10/17</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 28939D

Part Number: D30657

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg D30657

SB 07/01/15

58

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/01/15 (58)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL/4L

07/01/16

58

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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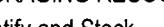


Comment: INSPECT CHEMICAL CONVERSION COAT

07/01/16

58

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GRC

07/01/16

58

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/01/17

58

Job Completion



07/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28939 D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

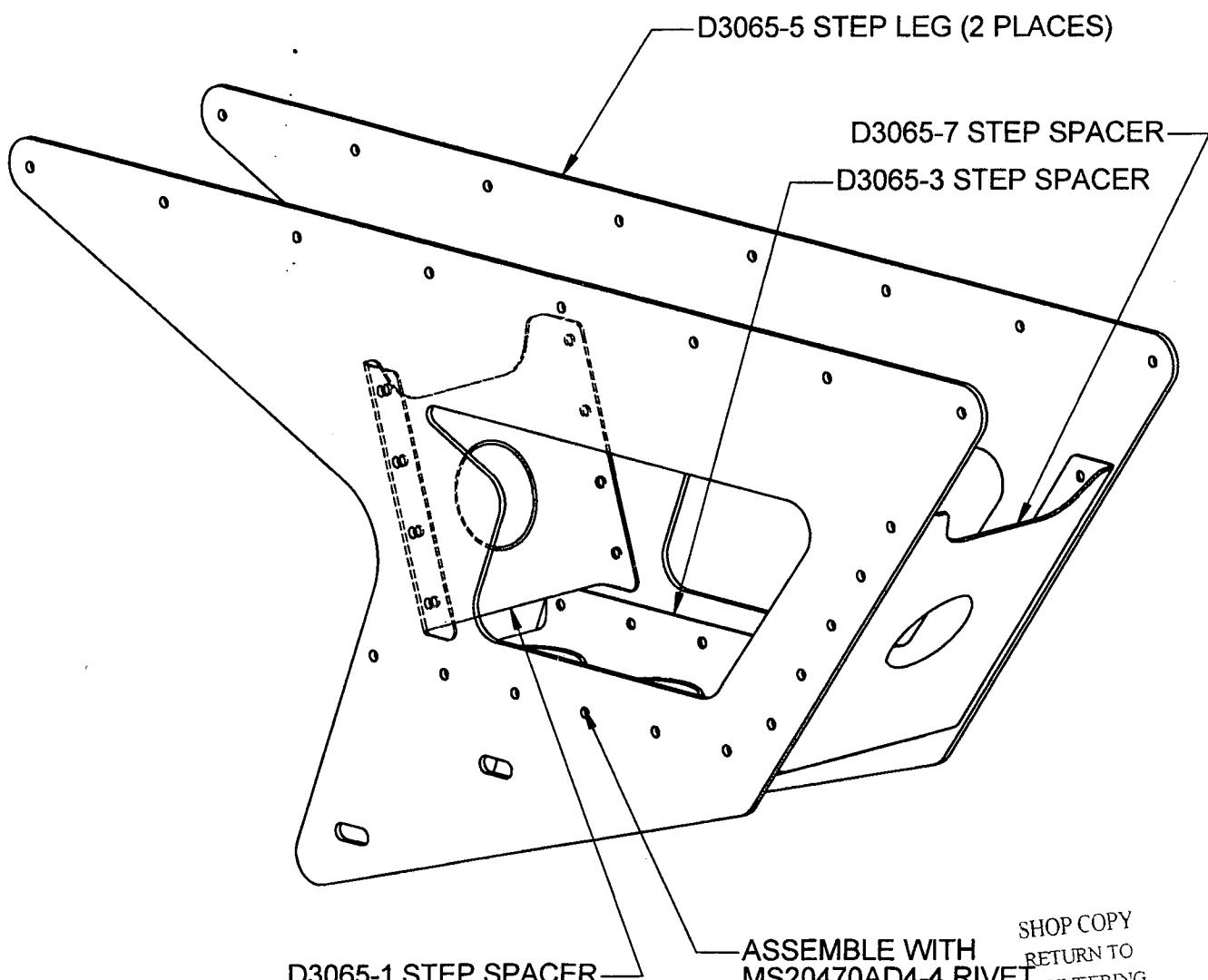
X First Article Prototype

Measured by:	SAR	Audited by:	AA	Prototype Approval:	N/A
Date:	06/10/28	Date:	06/10/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE	1:2
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED*06.06.20 TH***D3065-041 STEP LEG ASSEMBLY**

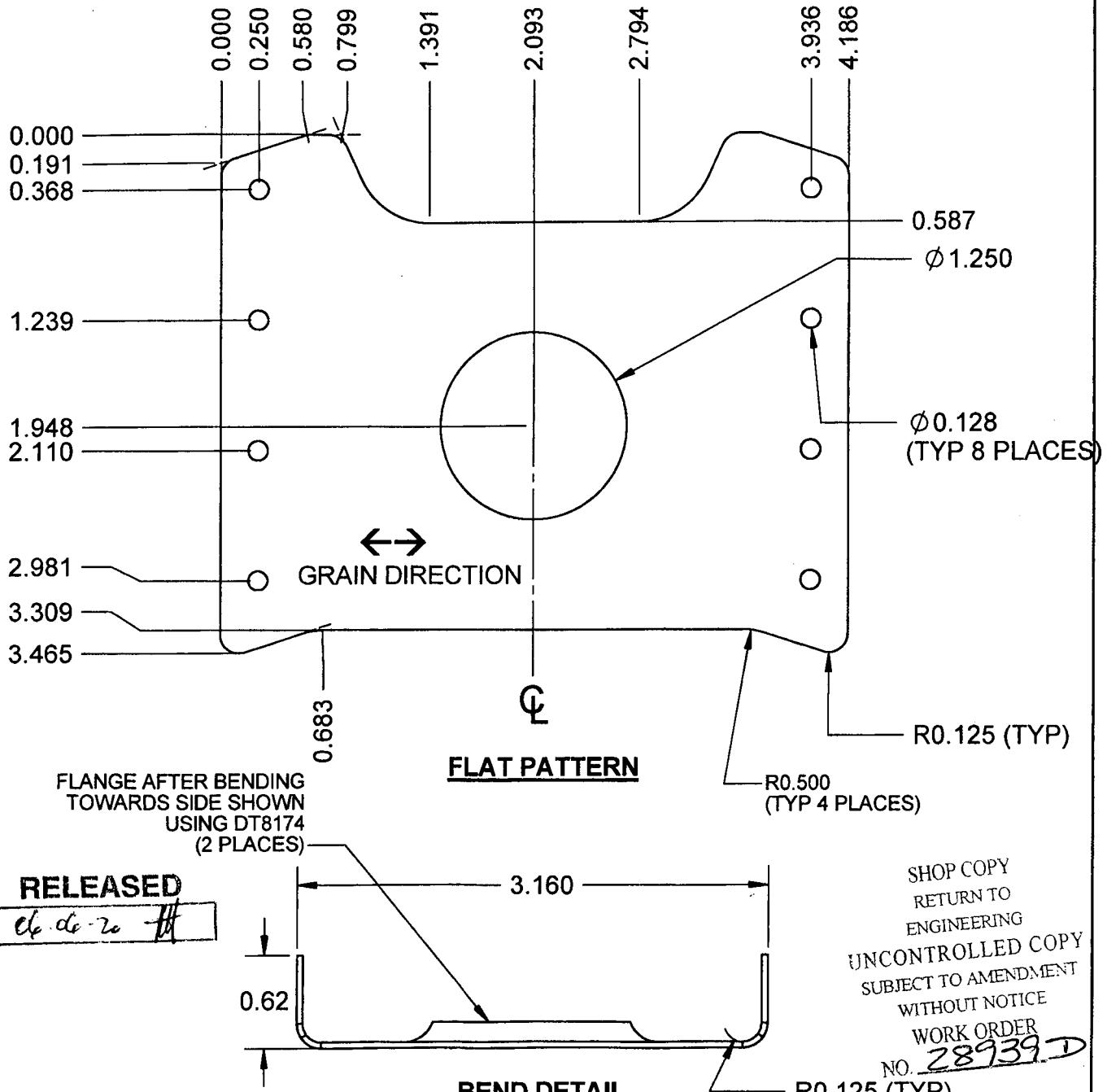
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NO. *28939 D*

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY

REV. B
SHEET 2 OF 5
SCALE 1:1**D3065-1 STEP SPACER**

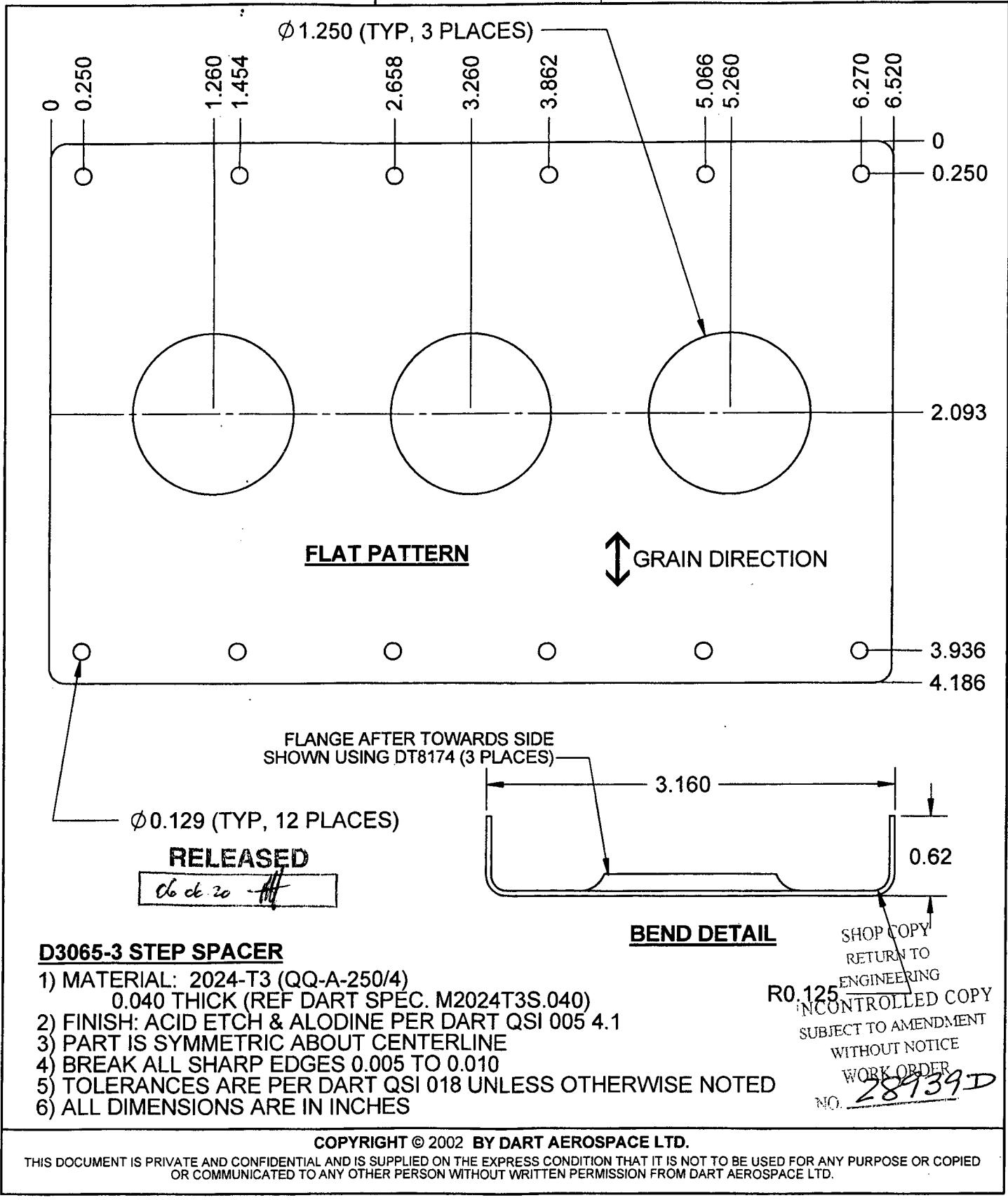
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1	



D3065-3 STEP SPACER

1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040) R

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) PART IS SYMMETRIC ABOUT CENTERLINE

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

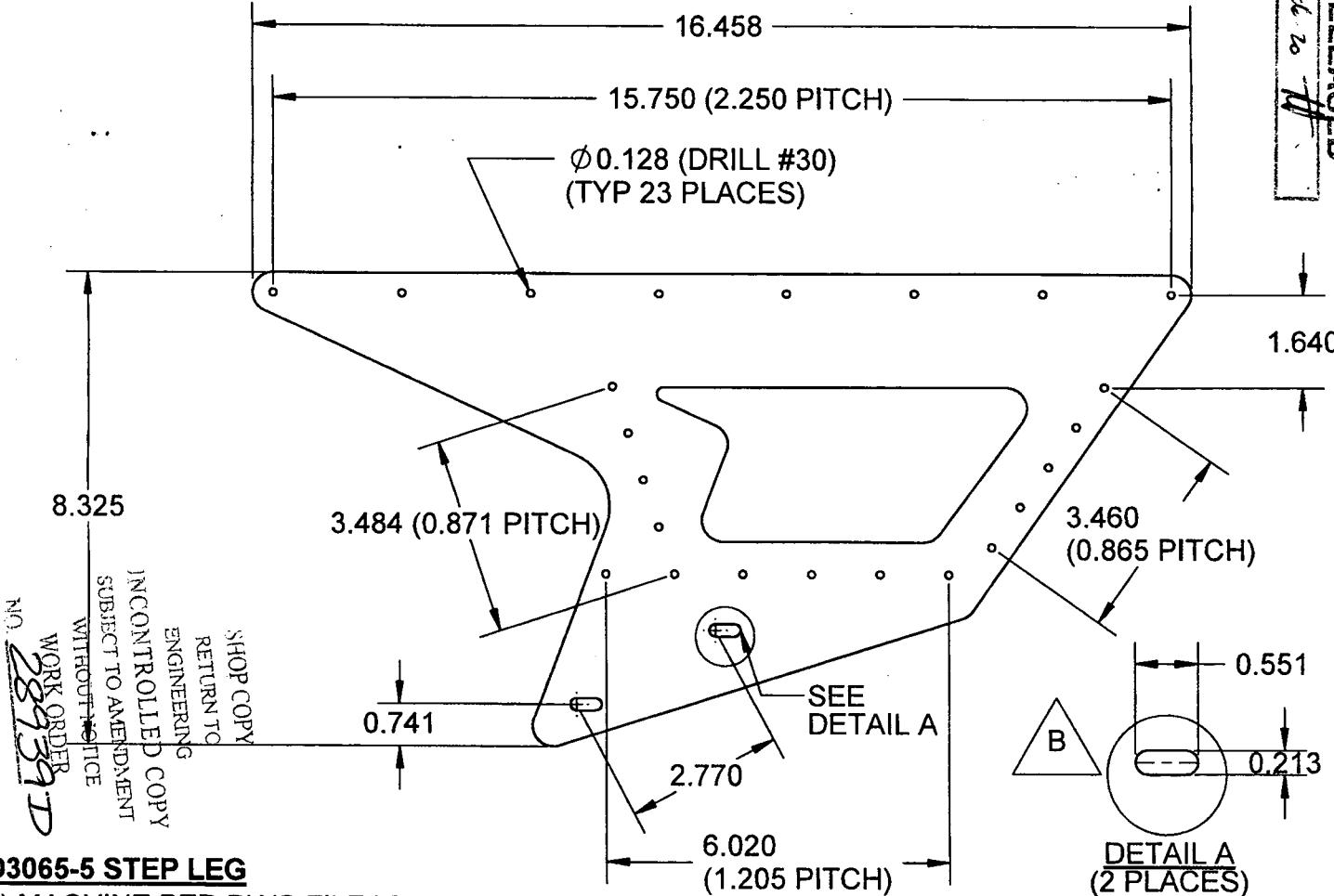
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06.01.20 11 RELEASED



D3065-5 STEP LEG

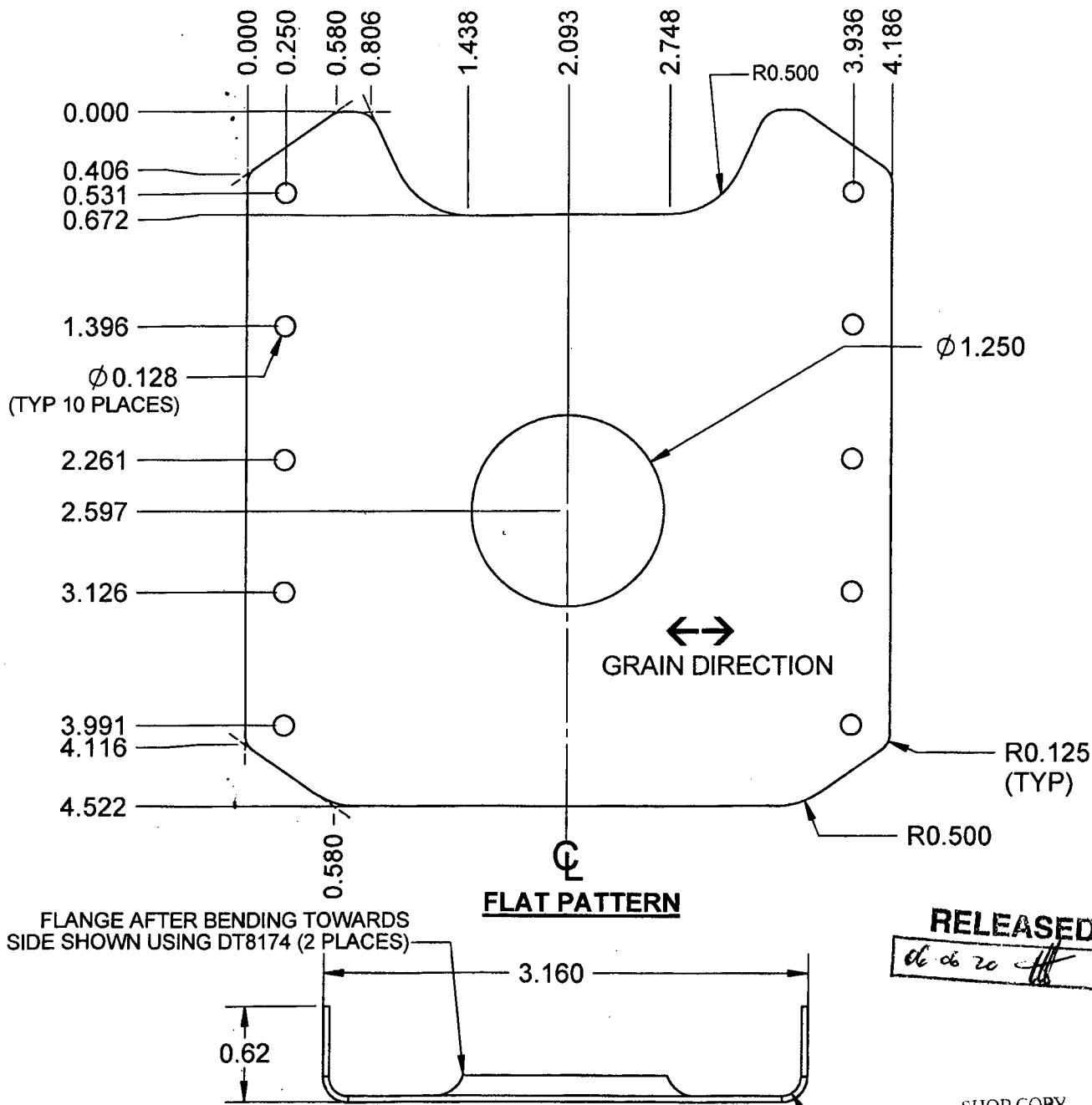
1) MACHINE PER DWG FILE "D3065-5.SLDPRT" (1.2051 INCH) (2 PLACES)
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

DESIGN	<i>10</i>	DRAWN BY	<i>C.B</i>
CHECKED	<i>PH</i>	APPROVED	<i>JK</i>
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY
		SCALE	1:3
		REV. B	SHEET 4 OF 5
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3065			

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DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1	



D3065-7 STEP SPACER

1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) ED COPY
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 SUBJECT TO AMENDMENT
3) PART IS SYMMETRIC ABOUT CENTERLINE WITHOUT NOTICE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES NO. 28939 D

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